

Work Order ID 81849

81849

Page 1

March-19-12 4:25:04 PM

Item ID: D4406-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Fwd Wearplate Assembly

Start Date: 19/03/2012 Start Qty: 8.00

8

Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: M-LJ

Date: 12/03/20

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4406

B

100

0.00

100

Waterjet

0.00

FLOW CNC Waterjet

304 . 050

Memo

1-Cut as per dwg D4406-1

prog rev: B

dwg rev: B

2-Deburr if required

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B / Jm 120404

B / Jm 120404

(8)

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Small Fab

Memo

0.00

Small Fab

Form as per dwg D4406

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

0.00

150

Large Fab

Memo

0.00

Weld bar as per dwg

A/R 2059b hardcoat Batch#: M121175

Weld bar to wearplate as per dwg

A/R s.s. rod Batch #: M120013

(x4) MAL 12/05/08

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

42 Ø 6/12.05.08

165

QC5- Inspect part completeness to step on W/O

0.00

165

QC

Memo

0.00

Quality Control

8/11/08

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Start Date: 19/03/2012 Start Qty: 8.00

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Cust Item ID:

Required Date: 02/04/2012 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170

170

Small Fab

Small Fab

Memo

Apply coating as per dwg D4406

0.00

0.00

12

05

08

4

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

4

φ

BLA59

190

190

Packaging

Packaging

Identify as per dwg & Stock Location: FP-1

Memo

0.00

0.00

4

φ

BLA59

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC21- Final Inspection - Work Order Release

0.00


200

QC

Memo

0.00

Quality Control

12/5/10 

ML 12/05/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

March-19-12 4:25:07 PM

Work Order ID: 81849

81849

Parent Item: D4406-041

D4406-041

Parent Item Name: Fwd Wearplate Assembly

Start Date: 19/03/2012

Required Date: 02/04/2012

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP rev A 11.06.06 new issue EC verified by:DD
12.02.06 as per dwg revPB1 DID verf:EC IPP rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S18GA

Purchased

No

100

sf

191.1180

3.5

29.47368

29.5

M304S18GA

304/316 .050 Sheet

**

Location

Loc Qty

Loc Code

MAT020

191.118

119032

10.3

119383

60.818

120604

120

121192

150

Each

0.0000

2

D4407-1

Manufactured

No

D4407-1

Bar

**

B 81852 x 8

121192 TD / Jm 120404 (8)
16
(x8) MAL 12/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81849
Description: Plate		Part Number:	D4406-1
Inspection Dwg: D4406	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.561	+/-0.010	0.565	✓		Vern	HB-02
0.30	+/-0.030	0.295	✓		Vern	HB-02
0.88	+/-0.030	0.88	-		Vern	HB-02
0.13	+/-0.030	0.13	✓		Vern	HB-02
1.77	+/-0.030	1.77	✓		Vern	HB-02
7.203	+/-0.010	7.200	✓		Vern	HB-02
7.80	+/-0.030	7.80	✓		Vern	HB-02
3.63	+/-0.030	3.63	✓		Vern	HB-02
7.00	+/-0.030	6.991	✓		Vern	HB-02
4.00	+/-0.030	4.006	✓		Vern	HB-02
36.00	+/-0.030	36.00	✓		MT	HB-01
66.06	+/-0.030	66.06	✓		MT	HB-01
2.43	+/-0.030	2.44	✓		Vern	HB-02
7.067	+/-0.010	7.063	✓		Vern	HB-02
7.77	+/-0.030	7.764	✓		Vern	HB-02
12.745	+/-0.010	12.745	✓		MT	HB-01
37.308	+/-0.010	37.308	✓		MT	HB-01
63.734	+/-0.010	63.734	✓		MT	HB-01
0.050	+/-0.010	0.047	✓		Vern	HB-02

Measured by: B/Jm	Audited by: S	Preliminary Approval:
Date: 120404	Date: 12/04/05	Date:

Rev	Date	Change	Revised by	Approved
A	11.10.13	New Issue P/O D4406-041	KJ	
B	12.03.08	Dimensions revised per Dwg Rev B	KJ	

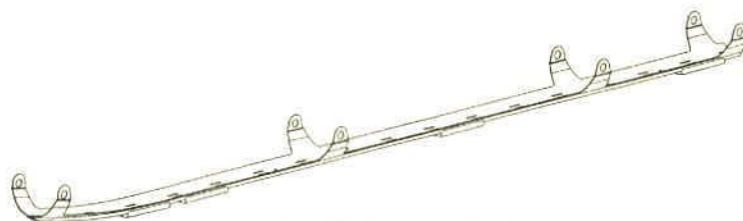
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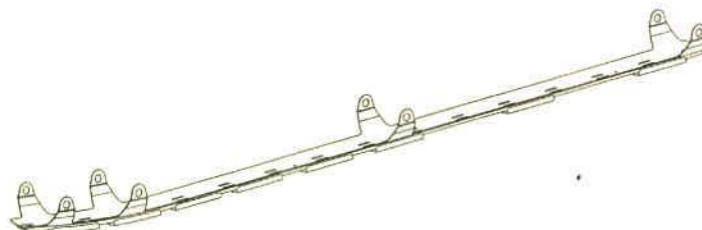
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NOTE: Date & initial all entries



D4406-041 FWD WEARPLATE ASSY



D4406-043 AFT WEARPLATE ASSY

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
1	X		D4406-041	FWD WEARPLATE ASSY
2		X	D4406-043	AFT WEARPLATE ASSY
3	1		D4406-1	PLATE
4		1	D4406-3	PLATE
5	2		D4407-1	BAR
6		2	D4407-3	BAR
7	A/R	A/R	2059B	HARDCOAT
8	A/R	A/R	4714	PLUS ONE ROCKGUARD (SEE NOTE 10, SHT 2 & 3)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 81849 MLJ

12/03/20

RELEASE
2012-02-23
MD

B	REVISE BILL OF MATERIAL, ADD NOTE 13/14 & REVISE NOTE 9 SHT 2 & 3, MODIFY DETAIL E & F (ZN B3-6, C2-6), ADD DETAIL G (ZN C7-6), REVISE D4406-3P TAB LOCATIONS (ZN B5-5)	RF	12.02.16
A	NEW ISSUE	RF	11.08.15
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4406	SHEET 1 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSY	NTS
DATE	12.02.16	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

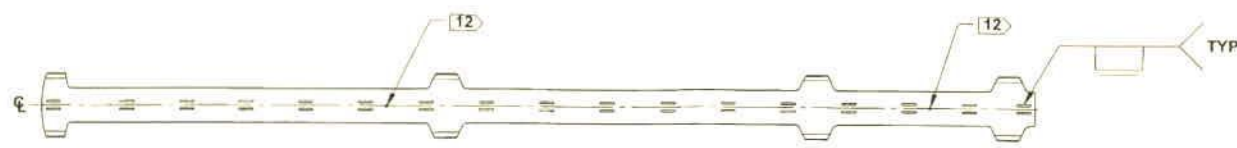
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

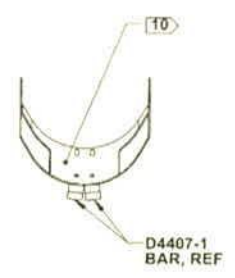
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NOTE: Date & initial all entries



21849



D4406-041 FWD WEARPLATE ASSY

SECTION A-A C3-2
SCALE 2X

RELEASED
2012-02-23

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6,1
 - 7) WEIGHT: 8.40 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-1 BAR ON LATERAL SURFACES
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
 - 11) FORM TO MATCH PROFILE OF D4406-1 AT TIME OF WELDING
 - 12) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-1 TO D4407-1
 - 13) NOTCH D4407-1 BARS AS REQUIRED TO FORM TO D4406-1 PLATE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4406	REV. B
MFG. APPR.	RF		SHEET 2 OF 6
APPROVED	RF	TITLE WEARPLATE ASSY	SCALE NTS.
DE APPR.	RF		
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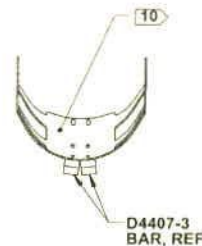
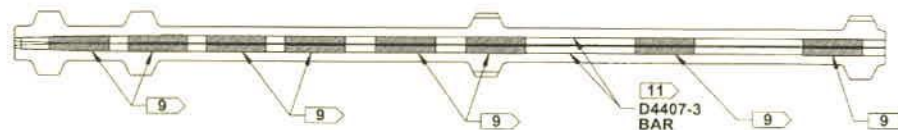
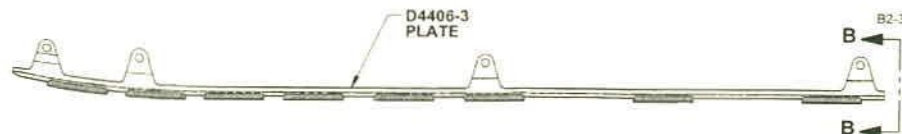
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4406-043 AFT WEARPLATE ASSY

SECTION B-B C3-3
SCALE 2X

RELEASE
2012-02-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 8.73 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.37 THICK x 0.50 WIDE, FLUSH WITH D4407-3 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) FORM TO MATCH PROFILE OF D4406-3 AT TIME OF WELDING
- 12) FILL TOOLING HOLE WITH WELD ONE PLACE ONLY
- 13) TRANSFER $\varnothing 0.188$ HOLES FROM D4406-3 TO D4407-3
- 14) NOTCH D4407-3 BARS AS REQUIRED TO FORM TO D4406-3 PLATE

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	<i>[Signature]</i>	DRAWING NO. D4406	REV. B
MFG. APPR	<i>[Signature]</i>		SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE WEARPLATE ASSY	SCALE
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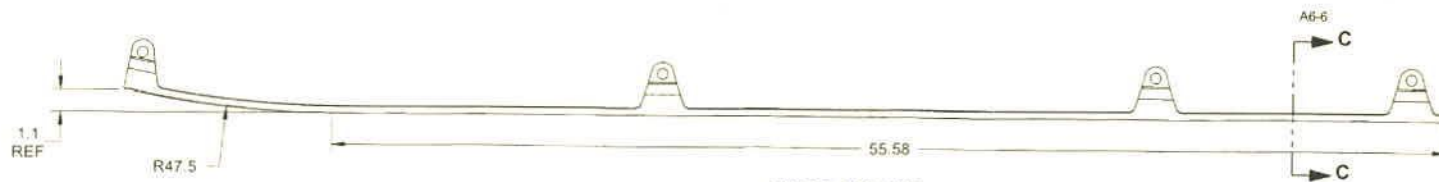
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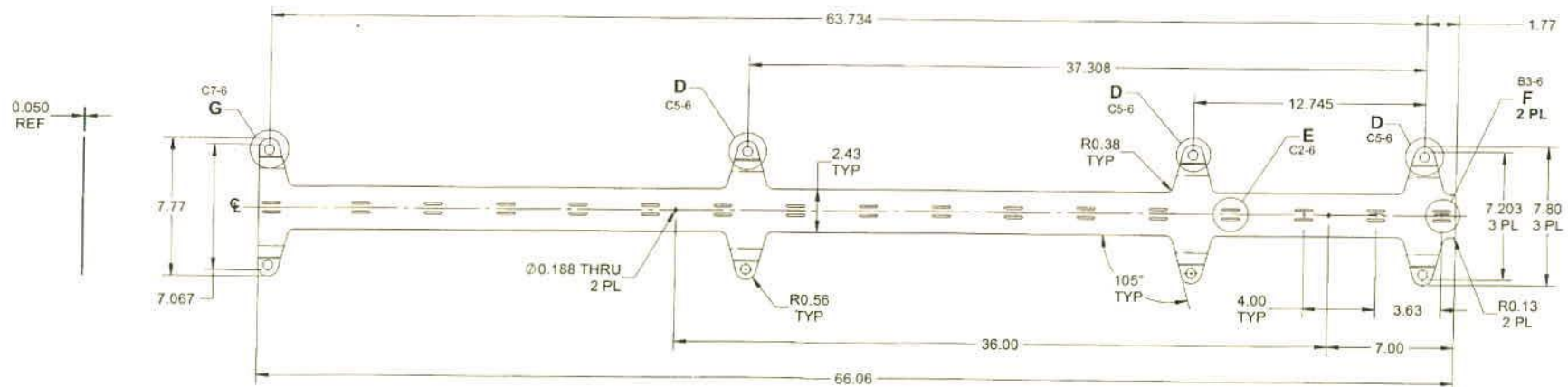
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NOTE: Date & initial all entries



D4406-1 PLATE
(MAKE FROM D4406-1F)



D4406-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.7 lbs

RELEASED
2012-02-23
M

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4406	REV. B
MFG. APPR.	RF	TITLE WEARPLATE ASSY	SHEET 4 OF 6
APPROVED	RF	SCALE	NTS
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DATE	12.02.16		

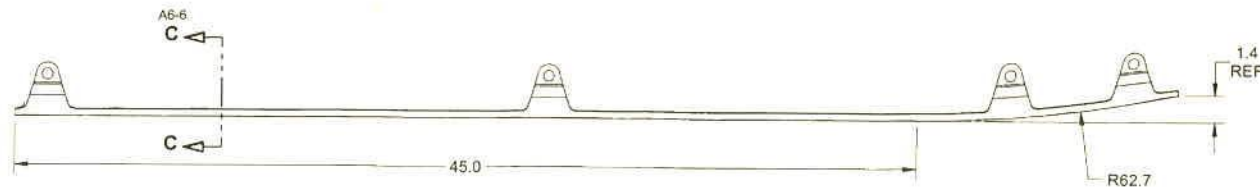
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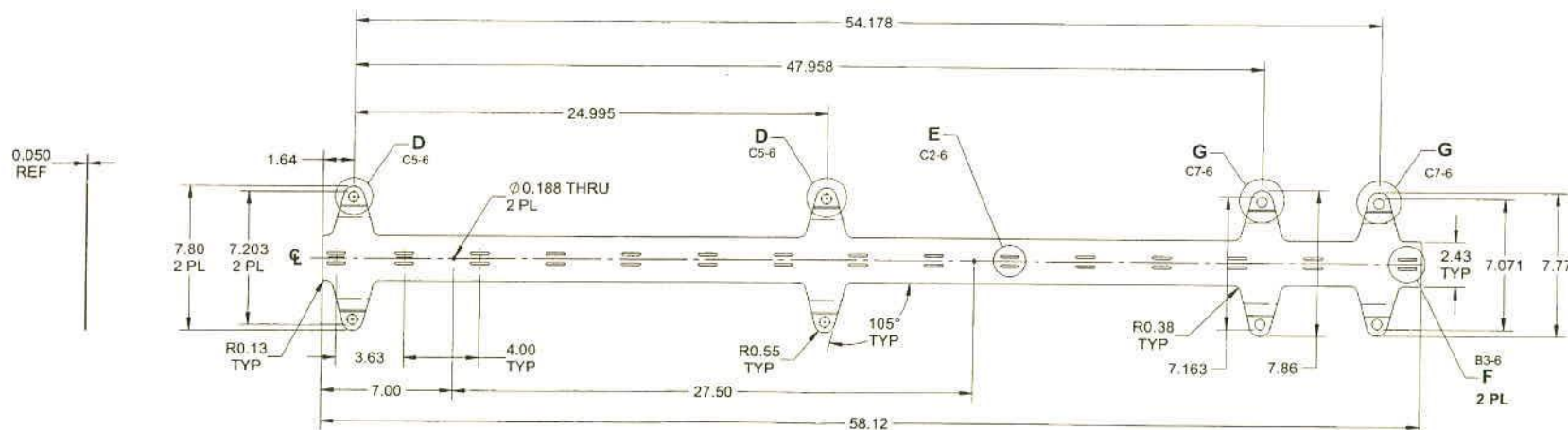
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NOTE: Date & initial all entries



D4406-3 PLATE
(MAKE FROM D4406-3F)

81249



B D4406-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.050 THICK (18 GAUGE)
PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.4 lbs

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2012-02-23
MJP

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO. D4406	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 5 OF 6	
APPROVED	<i>[Signature]</i>	TITLE WEARPLATE ASSY	SCALE NTS
DE APPR.	<i>[Signature]</i>	<small>COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	12.02.16		

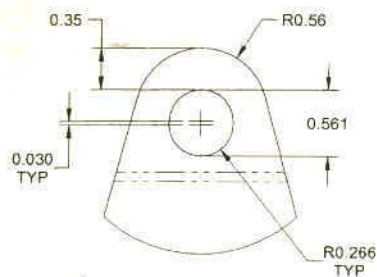
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

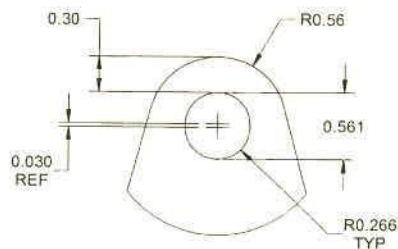
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



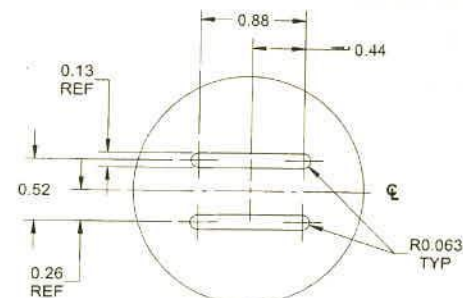
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SLOT DETAIL TYP
SCALE 6X

C7-4
C2-5
C3-5



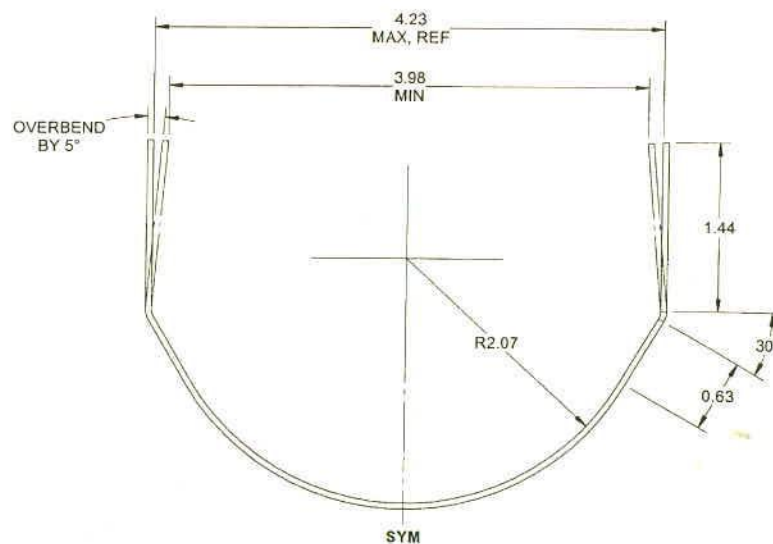
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SLOT DETAIL TYP
SCALE 6X

C2-4
C3-4
C5-4
C5-5
C6-5



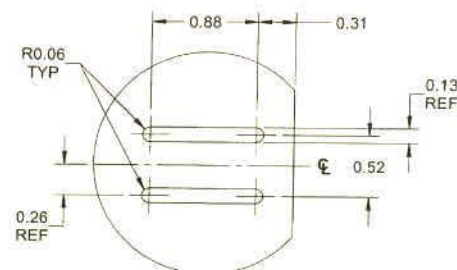
DETAIL E
SLOT DETAIL TYP
SCALE 6X

81849



DETAIL C
DETAIL TYP
SCALE 6X

D2-4
D6-5



DETAIL F
SLOT DETAIL TYP
SCALE 6X

C1-4
B1-5

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED	RF	DRAWING NO. D4406	REV. B
MFG. APPR.	RF		SHEET 6 OF 6
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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